

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018970**Date Inspected:** 17-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Guo Yan Fei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW):

Weld joint # 03 located on Lift-6 Tower Head component ND1 – FFSA6 – 3. Welder is identified as 053869.

ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – ESAB.

Weld joint # 07 located on Lift-6 Tower Head component ND1 – FFSA6 – 3. Welder is identified as 040302.

ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – ESAB.

Weld joint # 04 located on Lift-6 Tower Head component ND1 – FFSA6 – 3. Welder is identified as 040533.

ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – ESAB.

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Weld joint # 08 located on Lift-6 Tower Head component ND1 – FFSA6 – 3. Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – ESAB.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of weld joint # 08 located on Bike Path BK004A – 032 as per the weld repair report # B-WR19147.

Welder is identified as 056200. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 1G (1F) – REPAIR.

Repair welding of weld joint # 10 located on Bike Path BK004A – 032 as per the weld repair report # B-WR19147.

Welder is identified as 057258. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 1G (1F) – REPAIR.

Repair welding of weld joint # 02 located on Bike Path BK004A – 032 as per the weld repair report # B-WR19147.

Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 1G (1F) – REPAIR. (See attached photo)

BAY#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 007812

Ultrasonic Testing (UT)

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Component. The weld designation reviewed as follows:

BIKE PATH

BK005A3 – 003 – 002

BK005A5 – 003 – 002

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 23 located on Bike Path BK004ASD1 – 022. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2211 – Tc – U4c.

Weld joint # 27 located on Bike Path BK004ASD1 – 022. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2211 – Tc – U4c.

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Flux Cored Arc Welding (FCAW):

Weld joint # 17 located on Bike Path BK004A2 – 023. Welder is identified as 066326. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112 – Plug.

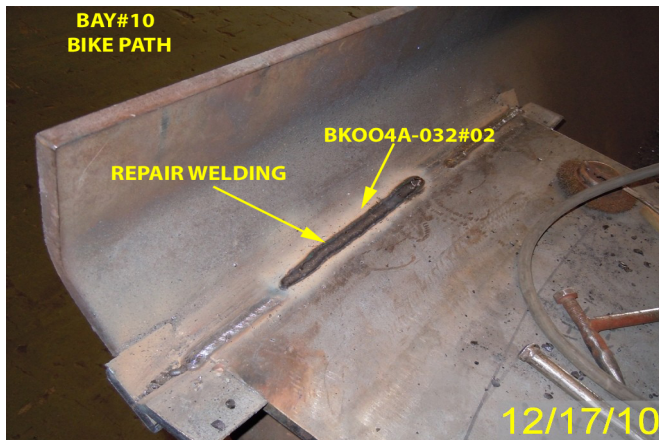
Weld joint # 07 located on Bike Path BK004A6 – 023. Welder is identified as 040704. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – ESAB.

Weld joint # 01 located on Bike Path BK004A6 – 023. Welder is identified as 042218. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – ESAB.

Weld joint # 02 located on Bike Path BK004A6 – 023. Welder is identified as 040704. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – ESAB.

Weld joint # 165 located on Bike Path BK004A6 – 023. Welder is identified as 042218. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho- 15002048250, who represents the Office of Structural Materials for your project.

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Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
